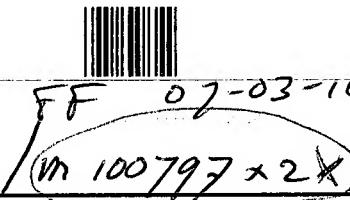


Ship 19/03

Dart Aerospace Ltd.

Date: Friday, 16/03/2007 7:09:24 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT	
Job Number	: 31245		Part Number	: D2565207	
Estimate Number	: 10959		Drawing Number	: D2565 REV E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	16/03/2007	S.O. No. : N/A	Drawing Revision	: E	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 19/03/2007 Qty: 5 Um: Each	
Previous Run	: 27072				
Written By	:				
Checked & Approved By	:				
Comment	: Est: D 01.08.2007 Added Powder coat, and added Inspection level 3 and 21. SM				
Additional Product					
Job Number: 					
Seq. #:	Machine Or Operation:	Description :			
1.0	M304TR0750W049	304 RD Tube .750 x .049W 			
Comment: Qty.: 1.8812 f(s)/Unit Total: 9.4059 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No:  FF 07-03-16 M102273 x 3 / M 100797 x 2 X					
2.0	BRAKE NC	NC BRAKE 			
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313  FF 07-03-16					
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and polish  MF. 07-03-19					
4.0	QC5	INSPECT WORK TO CURRENT STEP 			
Comment: INSPECT WORK TO CURRENT STEP  M 07/03/19 (5)					
5.0	POWDER COATING	POWDER COATING  M 103706 Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3  M-f 07/03/19 (5x)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/03/2007 7:09:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 31245

Part Number: D2565207

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/03/19 15:09

Comment: INSPECT POWDER COAT

7/03/19 (4)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/03/19 (4)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



4

Comment: FINAL INSPECTION/W/O RELEASE

7/03/20 (4)

Job Completion



7/03/20 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

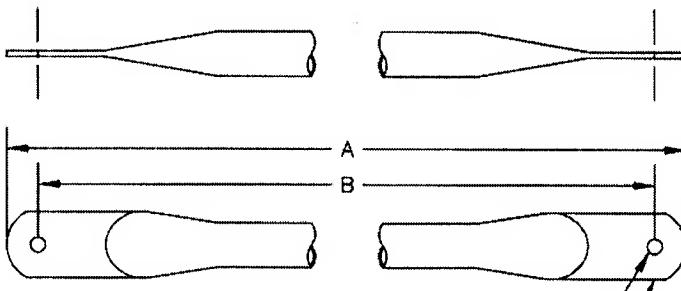
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

W/0
7/12/95



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DNY	APPROVED J	DRAWING NO. D2638
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL
		SCALE 1:1
A	98.04.28	NEW ISSUE

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117

